

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019955**Date Inspected:** 28-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Mr. Huang Min**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG BAY 5 to 8**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

**BAY 6**

Flux Cored Arc (FCAW) welding of welds joint FB3168-004-025, And Welder is identified as 053609, ZPMC Quality Control (QC) is identified as Mr. Zhong Zhi Wei. The welding variables appeared to comply with the Applicable WPS-B-P-2232-TC-U4b-F.

Shielded Metal Arc (SMAW) welding of Weld Joint FB3168-002-035, And Welder is identified as 048659, ZPMC Quality Control (QC) is identified as Mr. Zhong Zhi Wei. The welding variables appeared to comply with the Applicable WPS-B-P-2214-TC-U4b.

**BAY 7**

FCAW welding of welds joint FB3244-002-095, And Welder is identified as 053609, ZPMC Quality Control (QC)

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is identified as Mr. Xu Hai Yang. The welding variables appeared to comply with the Applicable WPS-B-T-2232-B-U2-F-2.

BAY 8

Shielded Metal Arc (SMAW) welding of Weld joint BK004A2-053-018, And Critical Welding Repair Report(CWR)B-CWR2114, Welder is identified as 045148, ZPMC Quality Control (QC) is identified as Mr. Liu Fa Wen. The welding variables appeared to comply with the Applicable WPS-345-SMAW-1G(1F)-Repair.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 07136

Ultrasonic Testing (UT)

This QA Inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a UT report for this date. The member is identified as Steel Barrier weld. The weld designations reviewed are as follows.

1. W2-SB10-008-050
2. W2-SB10-009-019,081
3. W2-SB10-010-050
4. W2-SB9-014-019,081
5. W2-SB9-015-019,050
6. W2-SB9-016-019,050
7. W2-SB9-017-081(Repair & I R generated)
8. W2-SB9-018-081
9. W2-SB9-20-050
10. W2-SB9-021-050

The following weld did not appear to comply with the contract documents: W2-SB9-017-081. This QA informed ZPMC QC identified as Huang min and ABF QA identified as Luo Lai Quan of this issue and that an incident report would be generated.

Please see the attached photos for more information.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 07142

Magnetic Particle Testing (MT)

This QA Inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a MT report for this date. The member is identified as bike path welds. The weld designations reviewed are as follows.

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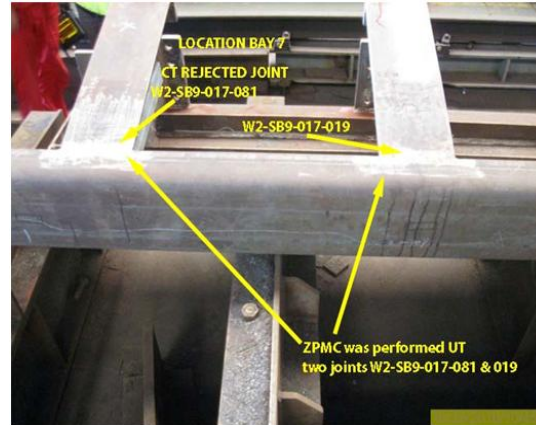
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1. BK004A4-054-056,058,030,032
2. BK004A5-054-024,025,123,124
3. BK004A6-054-072,073,100,102,096,098

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Michael Ng (15921845703), who represents the Office of Structural Materials for your project.

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**Inspected By:** Tharikoppada,Reddy

Quality Assurance Inspector

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**Reviewed By:** Miller,Mark

QA Reviewer